

IN THE CLAIMS:

What is claimed as being new and therefore desired to be protected by letters patent of the United States is as follows:

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1. In a spruing assembly comprising:

a runner bar for connecting to a base unit surrounded by a casting ring;

at least one sprue connected at a second end to the
10 runner bar, said sprue having an opposed first end for connecting to at least one wax structure formed in a pattern to be cast, the improvement comprising:

a curved adapter disposed at the second end of the sprue, said adapter being sized and shaped to lock onto
15 said runner bar in a secure engagement.

2. The spruing assembly as described in claim 1 wherein the adapter has a radius of a first predetermined length, and the runner bar has a radius of a second predetermined
20 length which is longer than the first predetermined length.

3. The spruing assembly as described in claim 1 wherein said sprue has a reservoir formed thereon.

4. The spruing assembly as described in claim 1 wherein at least the first end of said sprue is hollow.

5. In a spruing assembly comprising:

5 a base unit removeably engaged to a casting ring to define a receptacle for receiving investment material for the making of castings; a sprue holding member connected to the base unit inside said receptacle; said improvement comprising:

10 at least one wax structure formed in a pattern to be cast;

at least one sprue having a first end and a second end, said first end connected to the wax structure; and,

a curved adapter disposed at the second end of the
15 sprue, said adapter of the second end connected to said sprue holding member; said adapter being sized and shaped to lock onto said sprue holding member in a secure engagement.

20 6. The spruing assembly as described in claim 5 wherein the adapter has a radius of a first predetermined length, and the sprue holding member has a radius of a second predetermined length which is longer than the first predetermined length.

7. The spruing assembly as described in claim 6 wherein the sprue holding member is a single elongated runner bar having an arcuate cross-section.

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8. The spruing assembly as described in claim 6 wherein the sprue holding member is a runner bar formed in the shape of a ring having a central plug and a plurality of radial bars extending from the central plug and connected to the ring, said central plug is connected to said base unit, said runner bar has an arcuate cross-section.

9. The spruing assembly as described in claim 5 wherein said sprue has a reservoir formed thereon.

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10. The spruing assembly as described in claim 5 wherein at least the first end of said sprue is hollow.

11. In a spruing assembly comprising:

20 a base unit removeably engaged to a casting ring to define a receptacle for receiving investment material for the making of castings; a sprue holding member connected to the base unit inside said receptacle; said improvement comprising:

at multi-unit wax structure formed in a pattern to be cast;

each unit of said multi-unit wax structure having a sprue connected thereto, each sprue having a first end and
5 a second end, said first end connected to the corresponding unit of said multi-unit wax structure; and,

a curved adapter disposed at the second end of each sprue, each adapter of each second end connected to said sprue holding member; each adapter being sized and shaped
10 to cover at least half of the circumference of the sprue holding member in locking onto said sprue holding member in a secure engagement.

12. The spruing assembly as described in claim 11 wherein
15 each adapter has a radius of a first predetermined length, and the sprue holding member has a radius of a second predetermined length which is longer than the first predetermined length.

20 13. The spruing assembly as described in claim 12 wherein the sprue holding member is a single elongated runner bar having an arcuate cross-section.

14. The spruing assembly as described in claim 12 wherein
the sprue holding member is a runner bar formed in the
shape of a ring having a central plug and a plurality of
radial bars extending from the central plug and connected
5 to the ring, said central plug is connected to said base
unit, said runner bar has an arcuate cross-section.

15. The spruing assembly as described in claim 11 wherein
each sprue has a reservoir formed thereon.

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16. The spruing assembly as described in claim 11 wherein
at least the first end of each sprue is hollow.

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